



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D4030-041
Job Sheet 190444



Part No: D4030-041

Job Qty: 1 pcs

Part Name: Long Basket Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 3/22/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: D4030 REV.D SHEETS 1,3,4 IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM IPP REV:E 18.12.03 CHANGE BOLT LENGHT AS PER CAR18-281 (AN3-14A TO AN3-15A) DD VERF:JFS

Ship Via:

Bill of Materials

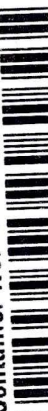
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs		3/22/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		

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Container No: S172507



Part: D4030-041

Job No: 190444

Serial No/Batch: S172507

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/15/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					Packaging 1 - 30	
					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
110 Handfinish - 4-1-Assembly-B4B	1 pcs	3/22/19	0.00 1.03	Handfinish - 4 - 1 - B4B		92 19.4.22
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
120 QC 5	1 pcs	3/22/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 42		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
130 Packaging 3-1 - Stock - B4B	1 pcs	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		

Entered: _____ Date: _____



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				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B	DAS	
				Packaging 3 - 34 - B4B	21	
				Packaging 3 - 35 - B4B	9-89	
				Packaging 3 - 36 - B4B		
140 QC 21 - SA	1 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21	DAS	
				QC 21 - SA - 70	21	
				QC 21 - SA - 53	9-89	
Part Op 100 - (Pick Kit) Descriptions: 110 - (Assemble as per dwg) 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)						

MAY 02 2019

MAY 02 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-15A	Bolt 5161920-1 (1x)	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	009268
AN3-16A	Bolt	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5149303-1
AN310-4	Nut	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5149288-3
AN310C4	Nut	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5167225
AN4-12	Bolt	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5156966
AN5-17A	Bolt	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5116813-2
D2530	Handle Weldment	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5161901
D2535	Spring	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	51541034
D2537	Bushing	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5183161
D3917-3	Washer	6 pcs (6 ea)	100-Packaging 1 - Pick Kit	5170157
D3953-17	Gas Spring Spacer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5160928
D3953-19	Gas Spring Bracket	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5143335
D3953-21	Gas Spring Bracket	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5150029
D3953-3	Gas Spring Stud, Lid	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5163194
D3953-7	Spring Spacer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5163881
D3953-9	Gas Spring Washer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5159218
D3969-3	Spring (Basket Lid)	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5163140
MS21042L3	Nut	6 Ea (6 ea)	100-Packaging 1 - Pick Kit	5157462-1
MS21042L5	Nut	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5149145-1
MS24665-151	Cotter Pin	3 Ea (3 ea)	100-Packaging 1 - Pick Kit	5144955
MS24665-300	Cotter Pin	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5157264
NAS1149C0432R	Washer	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5103990-1
NAS1149F0332P	Washer	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	5155976
NAS1149F0432P	Washer	6 Ea (6 ea)	100-Packaging 1 - Pick Kit	5152652-2
NAS1149F0563P	Washer	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5098031
D3913-041	Long Basket Base Assembly, 350	1 pcs (1 ea)	110-Handfinish - 4-1-Assembly-B4B	X 5149141
D3914-041	Long Basket Lid Assembly (350)	1 pcs (1 ea)	110-Handfinish - 4-1-Assembly-B4B	5169928

009351

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	AN3-15A	4	148	0
	AN3-16A	2	77	0
	AN310-4	3	118	0
	AN310C4	2	92	0
	AN4-12	3	94	0
	AN5-17A	4	183	0
	D2530	1	1	0
	D2535	2	47	0
	D2537	2	120	0
	D3917-3	6	74	0
	D3953-17	2	53	0
	D3953-19	1	41	0
	D3953-21	1	47	0
	D3953-3	2	67	0
	D3953-7	2	52	0
	D3953-9	2	43	0
	D3969-3	1	33	0
	MS21042L3	6	2,712	0
	MS21042L5	4	867	0
	MS24665-151	3	556	0
	MS24665-300	2	29	0
	NAS1149C0432R	2	1,469	0
	NAS1149F0332P	8	3,006	0
	NAS1149F0432P	6	604	0
	NAS1149F0563P	4	512	0
110-Handfinish - 4-1-Assembly-B4B	D3913-041	1	4	0
	D3914-041	1	19	0
Part Specifications				
Specifications could not be found.				

Plex 2/8/19 12:50 PM dart.white.jesse

Entered: _____ Date: _____



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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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